

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007088**Date Inspected:** 27-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

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This QA inspector performed Visual Testing (VT) and Magnetic Particle Testing (MT) verification of the areas previously tested and accepted by ZPMC and ABF Quality Control personnel for Green Tagging . Ther member is identified as Tower Shear Plate A25.The weld identification is as follows: WD1-A25 B/E 125 through 172, 189 through 236, 094 through 097, 102 through 105, 110 through 113, 119 through 121, 124, WD1-A25 A/E 019 and 040. This QA inspector signed Green Tag 6752 along with ZPMC and ABF Quality Control Personnel.

This QA inspector performed conventional Ultrasonic (A scan) Inspection of tack welds on deck panels. Indications located within the area of interest were marked and recorded for phased array evaluation. This QA inspector performed UT on deck panel DP338-002 (9AE) and DP122-002 (9AW). The following summary below shows total of tack weld locations scanned, amount of indications and the percentage of indications for tack welds inspected on the panel.

DP338-002:

Weld 1, 19 tacks scanned with 1 indication

Weld 2, 19 tacks scanned with 1 indication

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Weld 3, 19 tacks scanned with 1 indication
Weld 4, 19 tacks scanned with 2 indications
Weld 5, 19 tacks scanned with 2 indications
Weld 6, 19 tacks scanned with 2 indications
Weld 7, 19 tacks scanned with 2 indications
Weld 8, 19 tacks scanned with 5 indications

152 tacks scanned with 16 indications (10.52%)

DP338-002:

Weld 1, 19 tacks scanned with 3 indications
Weld 2, 19 tacks scanned with 5 indications
Weld 3, 19 tacks scanned with 2 indications
Weld 4, 19 tacks scanned with 1 indication

76 tacks scanned with 11 indications (14.47%)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general between QA and QC occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134 8257 0045, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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